

Work Order ID 55014

January 5, 2010 12:57:42 PM



Page 1

Item ID: D2734

Accept



Setup Start



Revision ID:

Stop



Item Name: Step End Plate

Start Date: 05/01/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

PD

Date: *10-1-05*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2734

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D 2734 ☒ Dwg Rev: *C* ☐ Prog Rev: *C* 2-
Deburr if necessary

5662 .063

B 10-1-13

(70)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-1-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ 8/10/11/13

counter
(+70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

SB 10/01/21

70 0

Small Fab

Form as per drawing D2734

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

=> Sculcul 21

counters

(770)

+

Quality Control

150



Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

SK 10-01-21

70 0

Packaging

W/O:		WORK ORDER CHANGES					
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Required Date: 15/01/2010 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/22 HJ
MF 10-1-21

W/O:		WORK ORDER CHANGES					
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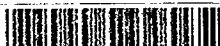
NOTE: Date & initial all entries

Picklist Print

January 5, 2010 12:57:46 PM

Page 1

Work Order ID: 55014



Parent Item: D2734



Parent Item Name: Step End Plate

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	111.8237	1.3158	4.7		
5052-H32 .063 Sheet												

B 10-1-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.8237

103755

1.3237

107276

14.5

112442

96

112442

70

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55014
Description: End Plate		Part Number:	D2734
Inspection Dwg: D2734	Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



X

First Article

1

Prototype

[illegible]

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 10-1-13	Date: 10/4/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.09.06	Dimensions added	KJ/JLM	
C	08.01.16	Dimensions revised per Dwg Rev. C	KJ/EC/DD	

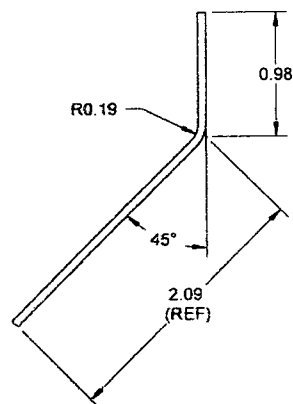
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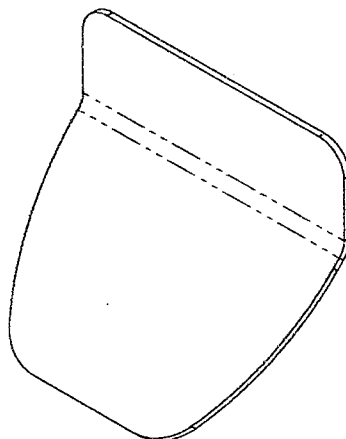
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NOTE: Date & initial all entries



D2734 END PLATE



D2734 FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T6) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55014
BY 10-1-05

RELEASED
07.12.10

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	95.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2734 TITLE END PLATE SCALE 1:1 <small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	KE		
CHECKED	KE		
MFG. APPR.	KE		
DE APPR.	KE		
DATE	07.11.20	REV. C SHEET 1 OF 1	

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